

ITEM #	QTY	PART #	PART TITLE
-103	1	RB T102137-107-103	STRAP
-105	1	RB T102137-107-105	PIN
-107	1	RB T102137-107-107	SLEEVE
-109	1	RB T102137-107-109	CLEVIS
110	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
111	1	McMaster#90630A165 OR EQUIV.	GRADE 8 STEEL NYLON INSERT LOCKNUT 5/8"-18 X 3/4" HT.
112	1	McMaster#90905A655 OR EQUIV.	316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.
113	1	McMaster#91772A826 OR EQUIV.	18-8 SS PHILLIPS PAN HEAD SCREW #10-32 X 5/16" LG.
114	1	McMaster#97840A460 OR EQUIV.	18-8 SS TAB FOR WIRE ROPE LANYARD 1.40" LG. X 1/2" WIDTH. X 1/16" THK.
115	1	AN10-47A	BOLT
116	2	NAS1149F1063P	WASHER
117	1	NAS133S6S10D	QUICK RELEASE PIN
118	1	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.

RB T102137-107 LIFTING TOOL

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DETAIL A

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH:
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RB T102137-107", S/N AND SWL AS SHOWN
- 7) ASSEMBLE AS SHOWN
- 8) TIGHTEN NUT UNTIL IT CONTACTS SURFACE, ENSURE 1-4 THREADS IN SAFETY
- 9) ASSEMBLED LANYARD LENGTH MUST BE 10" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 117
- 10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 113 THEN ASSEMBLE WITH ITEM -105, AND REMOVE EXCESS
- 11) INSTALL ITEM 113 HAND TIGHT
- 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SEE PREVIOUS REVISION FOR MORE INFORMATION

UPDATED DRAWING TEMPLATE

ITEM -111 WAS NAS6610-64 IS ITEM 115 AN10-47A
ITEM -113 WAS MS20002C10 IS ITEM 116 NAS1149F1063P
ITEM -115 WAS NAS1291-10 IS ITEM 111 McMaster#90630A165 OR EQUIV. ITEM -117 WAS MCMASTER-CARR #90272A238 IS ITEM 113 McMaster#91772A826 OR EQUIV.
REMOVED ITEMS -119, -125, AND -129

-103 MATERIAL WAS 4140/4142 IS 4140. FINISH WAS CAD PLATE YELLOW IS ZINC PLATE YELLOW. DIM WAS Ø.6260-.6245 IS Ø.641. DIM WAS (1.25) IS 1.25. REMOVED ENGRAVING NOTES. REMOVED 0.75 AND 0.63 DIMS. ADDED 4.00 DIM.

-105 MATERIAL WAS 4140/4142 IS 01. FINISH WAS CAD PLATE YELLOW IS ZINC PLATE YELLOW. HEAT TREAT WAS RC 46-50 IS 48-52 RC. DIM WAS Ø.194 IS Ø.196. DIM WAS 10-24 UNC V.50 IS 10-32 UNF V.31. REMOVED .63 DIM. ADDED 4.00 DIM. ADDED CYLINDRICITY GD&T TOLERANCE, ADDED R0.008 MAX.

-107 MATERIAL WAS 4140/4142 IS 4140. FINISH WAS CAD PLATE YELLOW IS ZINC PLATE YELLOW. HEAT TREAT WAS RC 32-37 IS 32-38 RC. DIM WAS Ø.627+.000/-0.002 IS Ø.641. DIM WAS 2.500+.000/-0.010 IS 2.493-2.488

-109 MATERIAL WAS 4140/4142 IS 4140. FINISH WAS CAD PLATE YELLOW IS ZINC PLATE YELLOW. DIM WAS 2.38 IS 2.493-2.488. DIM WAS Ø.504-.501 IS Ø.510-0.506. REMOVED .25, Ø.086 V.75, 2.00, 1.19, .629, AND 1.38 DIMS. REMOVED ENGRAVING NOTE.

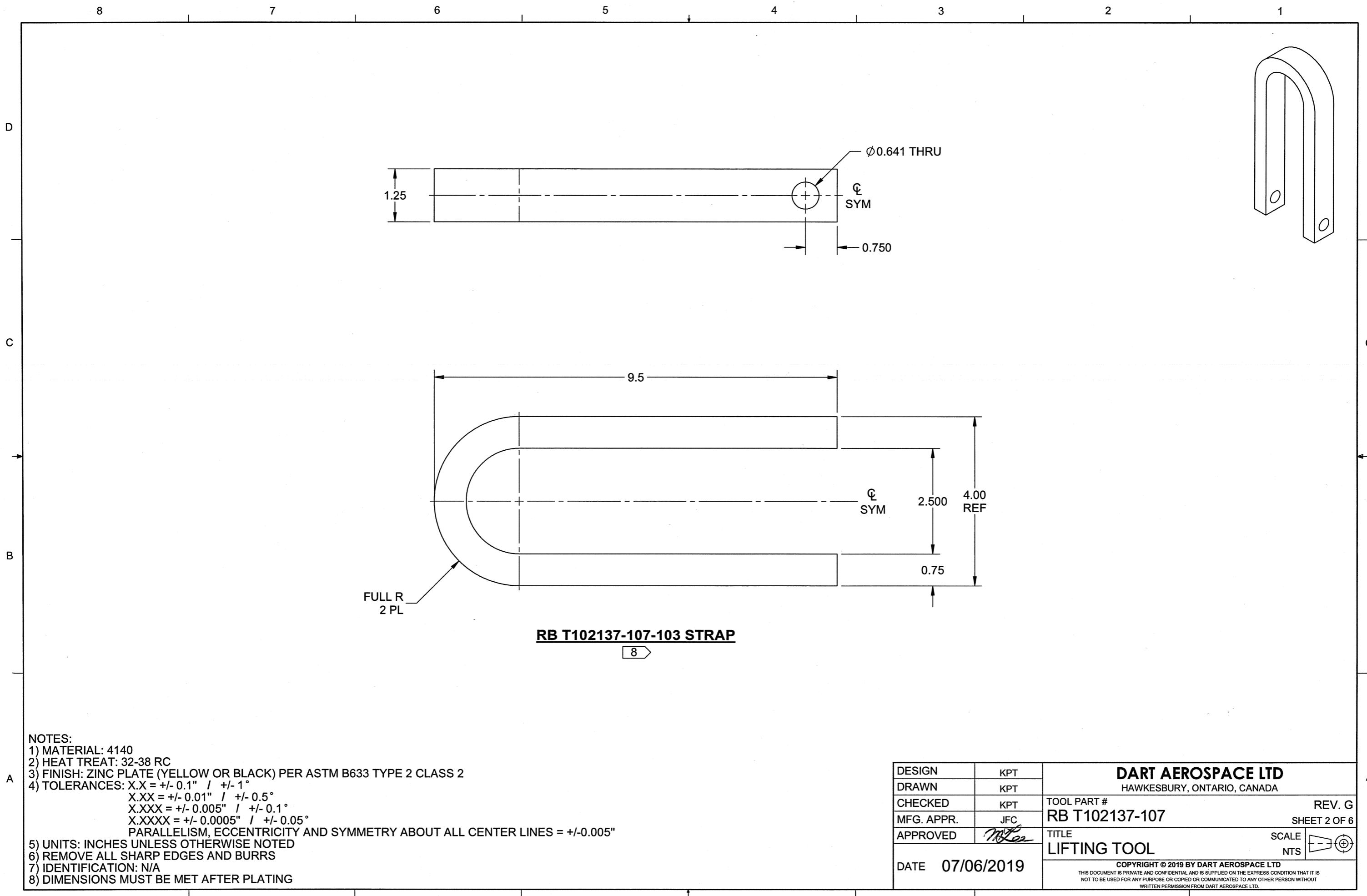
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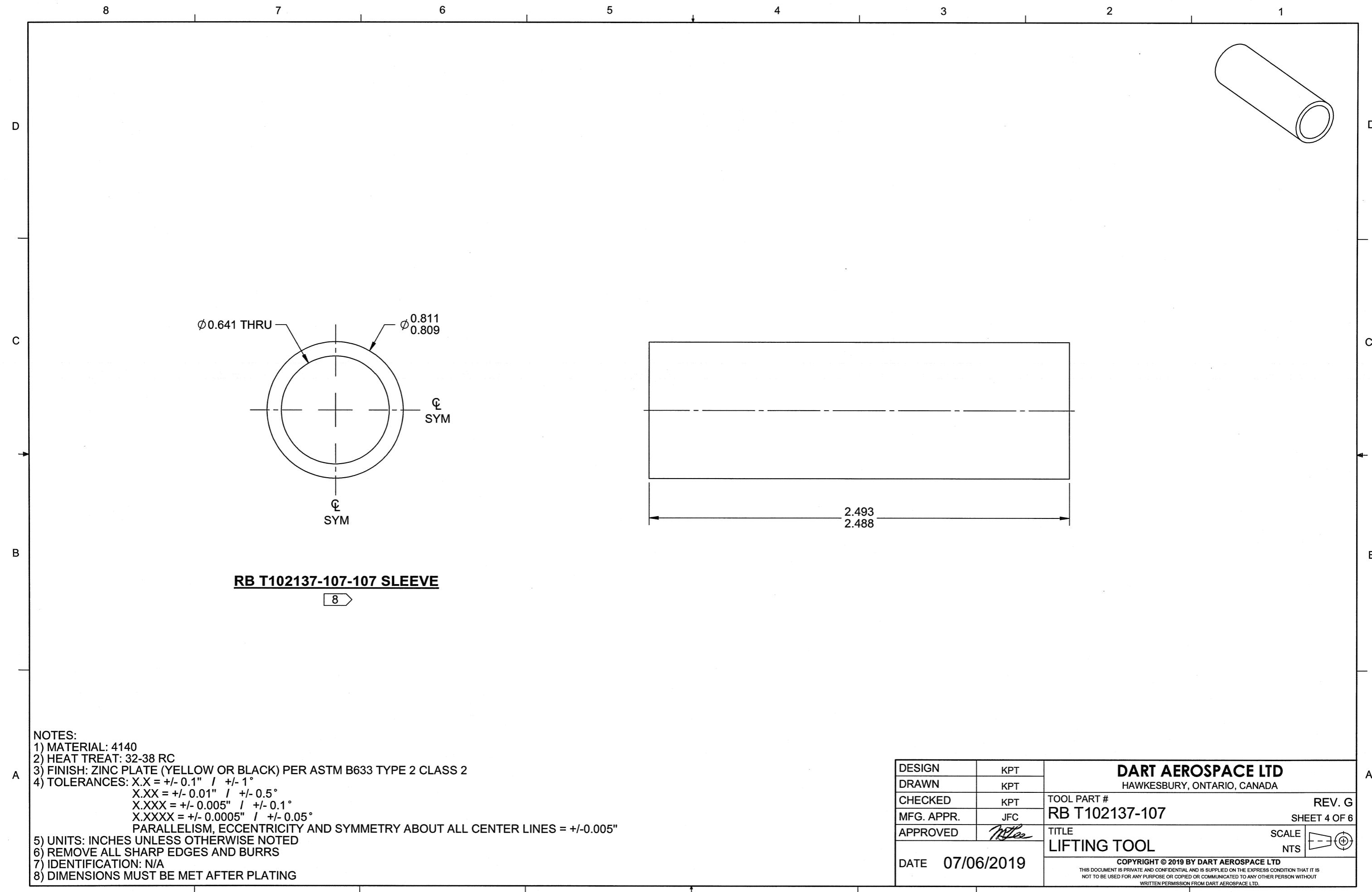
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. G	
MFG. APPR.	JFC	TOOL PART #	
APPROVED	<i>[Signature]</i>	RB T102137-107	
		SHEET 1 OF 6	
		TITLE	
		LIFTING TOOL	
		SCALE	
		NTS	

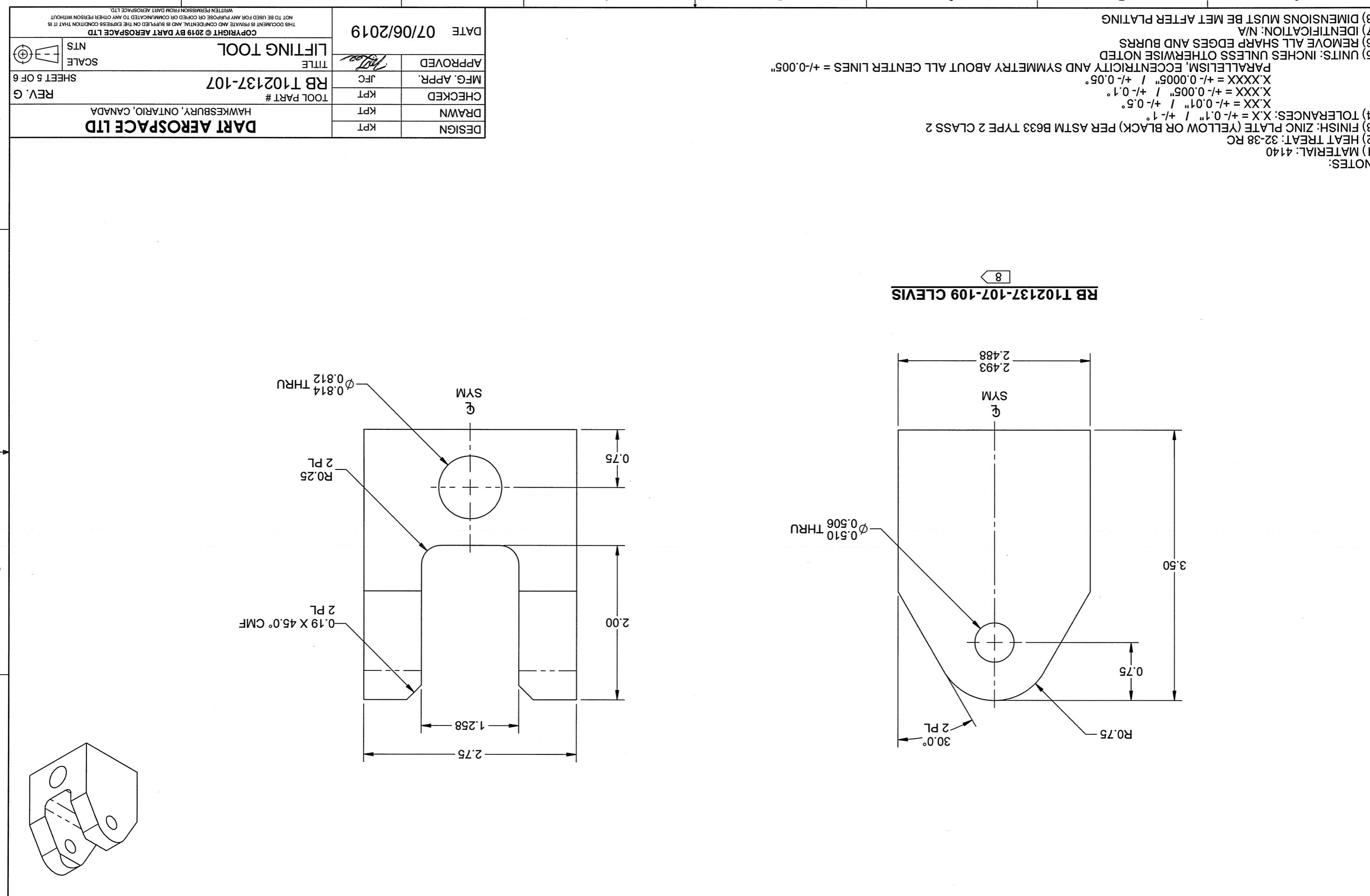
DATE 07/06/2019

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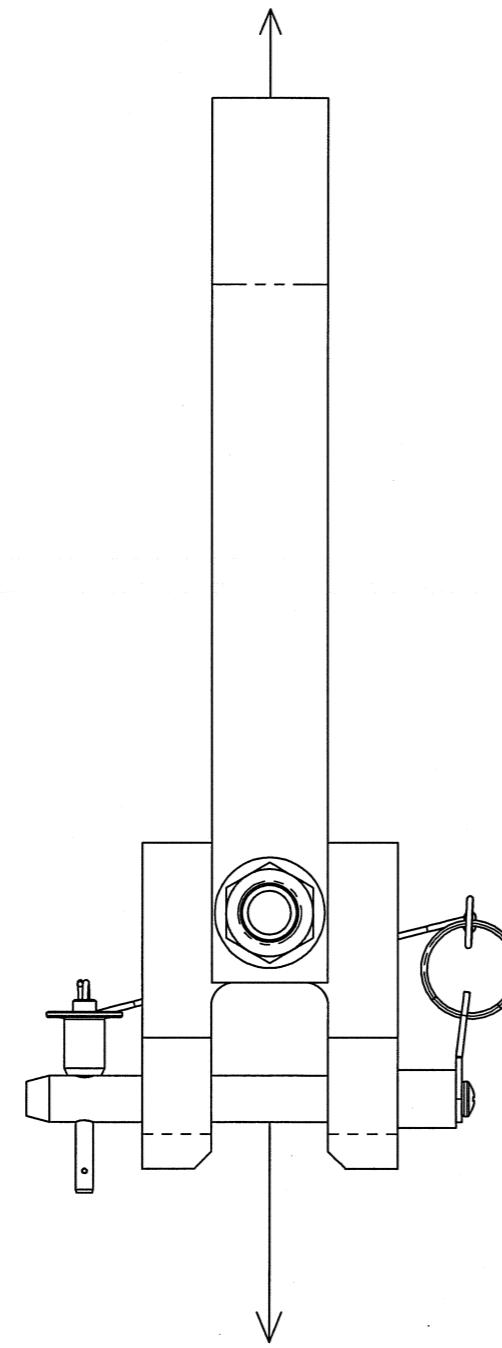
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B

B

A

A



10909 KG / 24000 LBS

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE LIFTING TOOL IN AN APPROPRIATE FIXTURE AND USE THE QUICK RELEASE PIN TO LOCK THE PIN INTO PLACE. ATTACH THE LIFTING TOOL TO AN APPROPRIATE TEST WEIGHT OF 10909 KG / 24000 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION
3. REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR: _____

TESTER: _____

S/N: _____

DATE: _____

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	JFC	REV. G	
APPROVED	<i>M. Lee</i>	RB T102137-107	
DATE 07/06/2019		SHEET 6 OF 6	
TITLE		SCALE	NTS
LIFTING TOOL			
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